

13

Date: Thursday, 3/13/2008 1:01:41 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212/205 HIGH AFT X-TUBE ASSEMBLY  
Job Number : 37991  
Estimate Number : 13218  
P.O. Number :  
This Issue : 3/13/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D212664201TRN  
First Issue : // Type : LANDING GEAR Drawing Number : D212-664-241 REV C  
Previous Run : 37990 Project Number : N/A  
Written By : Material :  
Checked & Approved By : Due Date : 3/28/2008 Qty: 1 Um: Each  
Comment : Est Rev: A 08-03-06 new issue DD verified by: ec

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description

1.0

D6006129

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube B

Check OD = 3.250"; ID = 2.220"

*Cancel**per Don 08-03-20*

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

4.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

3-Remove sand and plugs

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/13/2008 1:01:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 37991

Part Number: D212664201TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and stock in kanban rack

Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37991
<b>Description:</b> Crosstube Assembly (205/212 High Aft)	<b>Part Number:</b>	D212-664-241
<b>Inspection Dwg:</b> D212-664-241 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

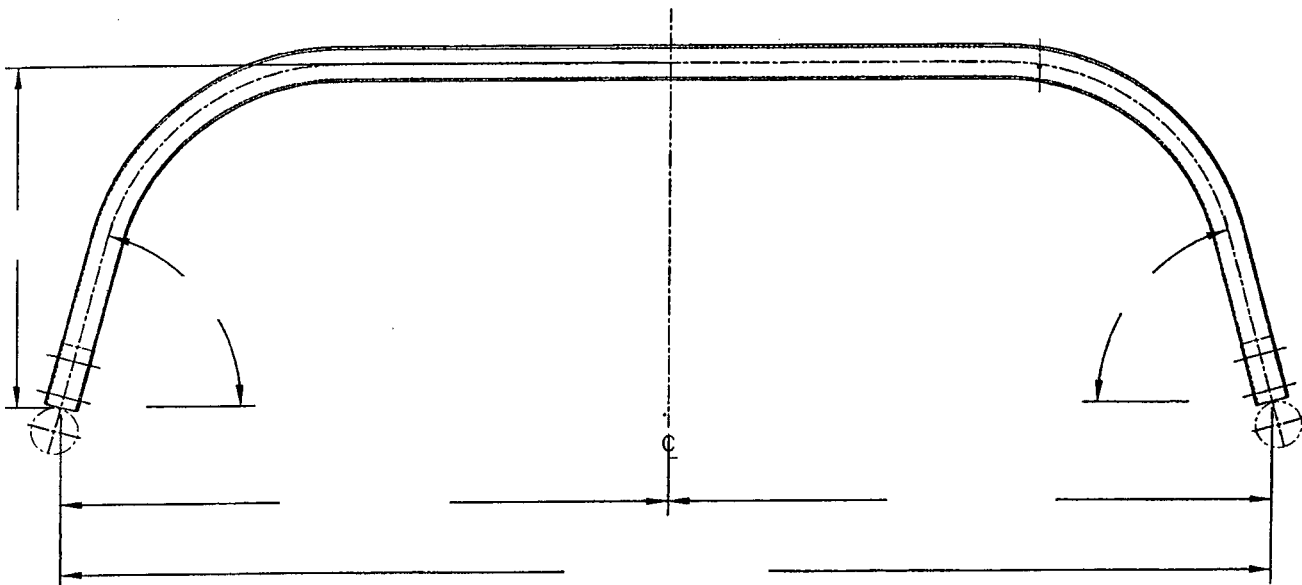
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010				
	R0.063	+/-0.010				
	2.990	+0.005/-0.000				
	5.237	+/-0.030				
	2.600	+0.005/-0.000				
	2.686	+0.005/-0.000				
	2.770	+0.005/-0.000				
	2.854	+0.005/-0.000				
	2.938	+0.005/-0.000				
	3.021	+0.005/-0.000				
	3.133	+0.005/-0.000				
	3.179	+0.005/-0.000				
SIDE B	0.200	+/-0.010				
	R0.063	+/-0.010				
	2.990	+0.005/-0.000				
	5.237	+/-0.030				
	2.600	+0.005/-0.000				
	2.686	+0.005/-0.000				
	2.770	+0.005/-0.000				
	2.854	+0.005/-0.000				
	2.938	+0.005/-0.000				
	3.021	+0.005/-0.000				
	3.133	+0.005/-0.000				
	3.179	+0.005/-0.000				
	124.36	+/-0.020				

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37991
<b>Description:</b> Crosstube High Aft (205/212)		<b>Part Number:</b>	D212-664-201
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> C		<b>Page 1 of 1</b>	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**  
*07.04.24 P*  
PER E.C.N 289

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

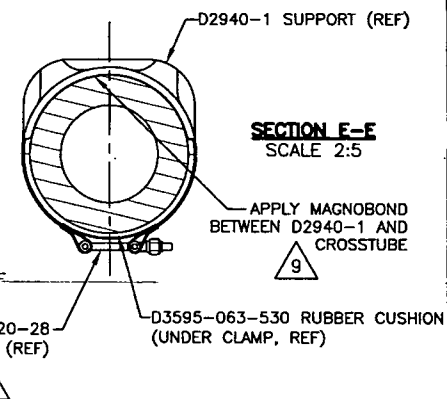
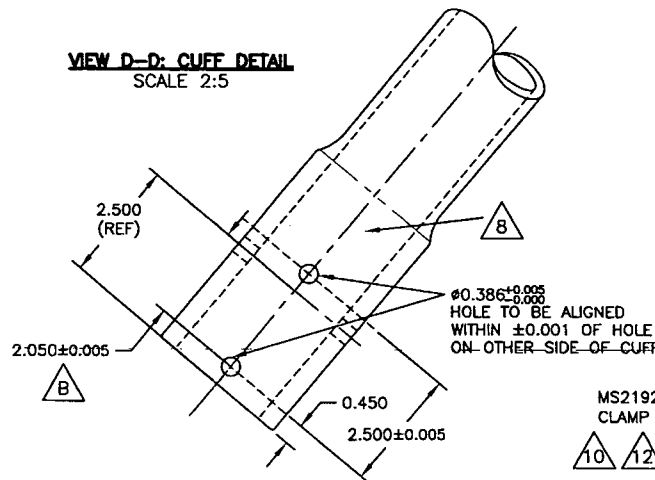
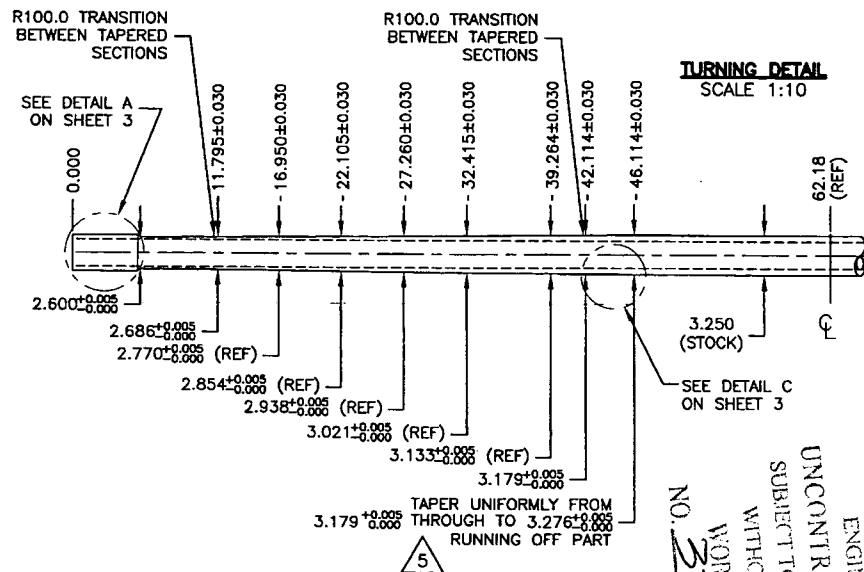
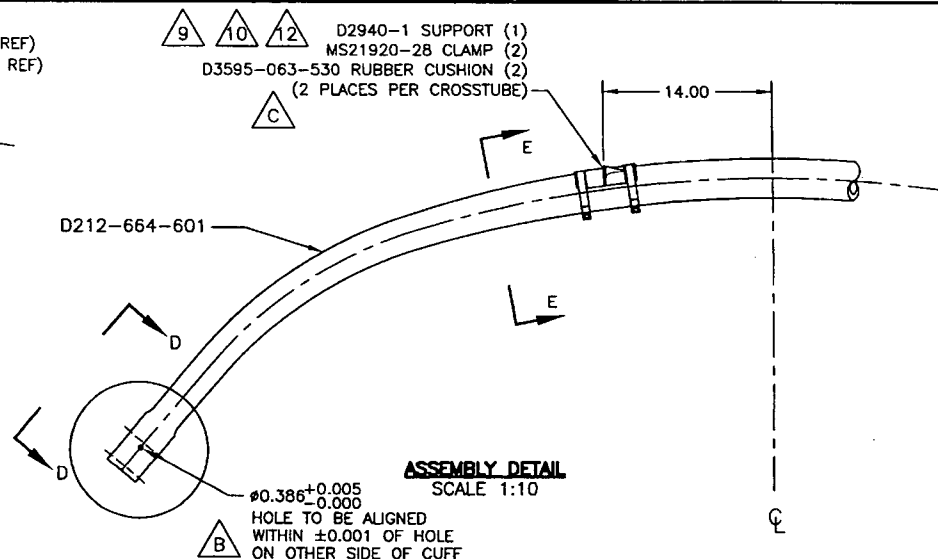
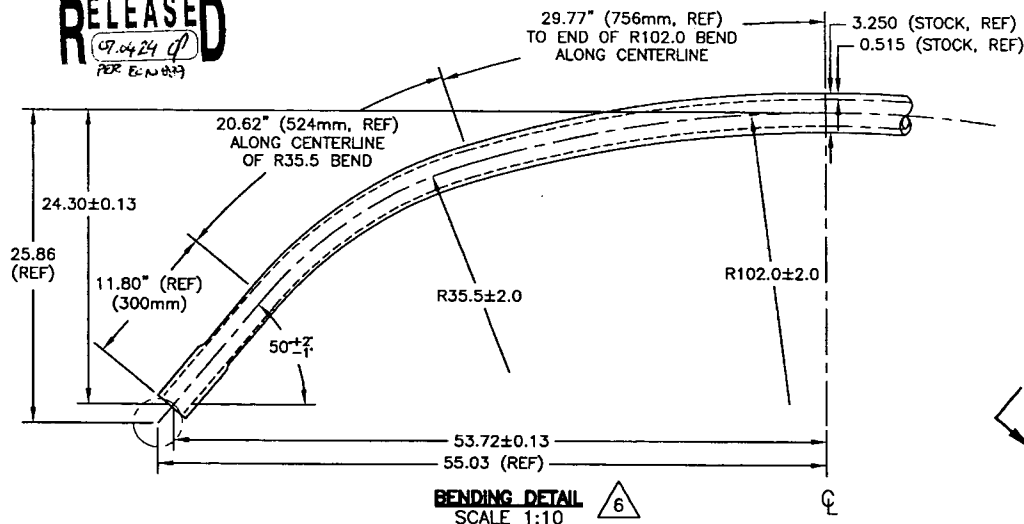
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.36±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- PART IS SYMMETRIC ABOUT CENTERLINE
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT  
**NOTE:** MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB.

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07.04.24  
PER E.N. 019



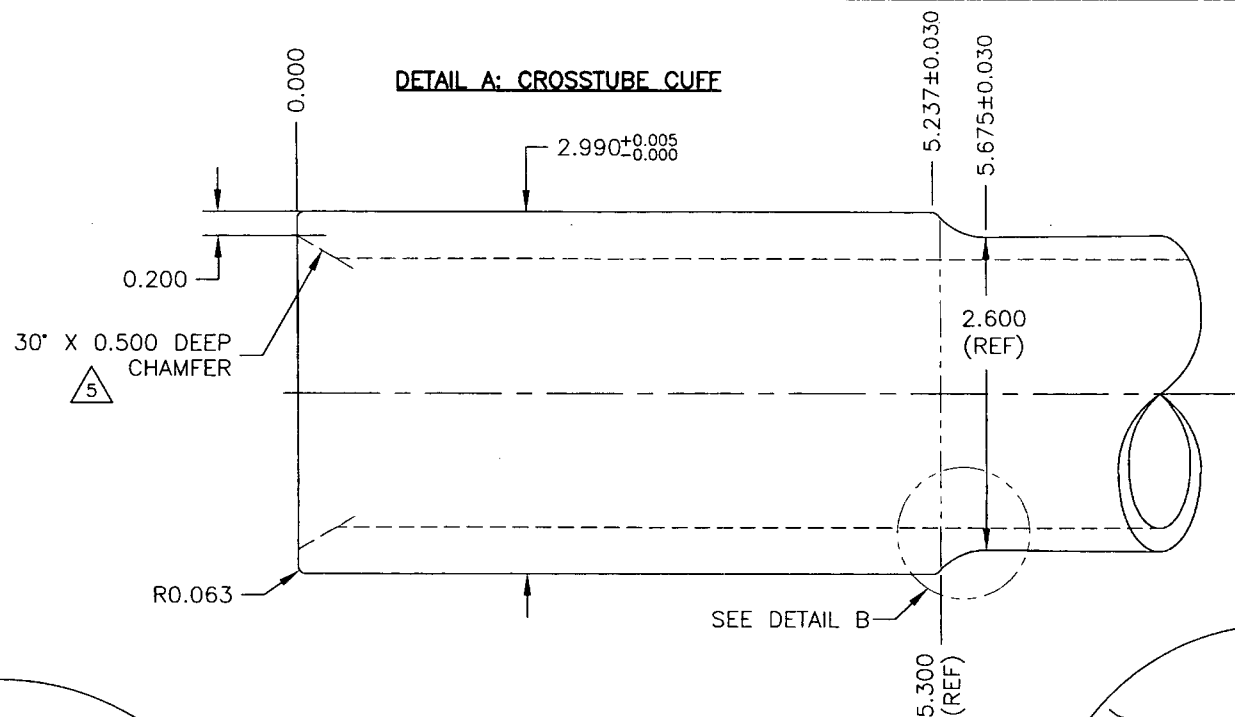
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		DATE	07.03.08	TITLE		CROSSTUBE ASS'Y (205/212 HI AFT)	
				SCALE		1:10	

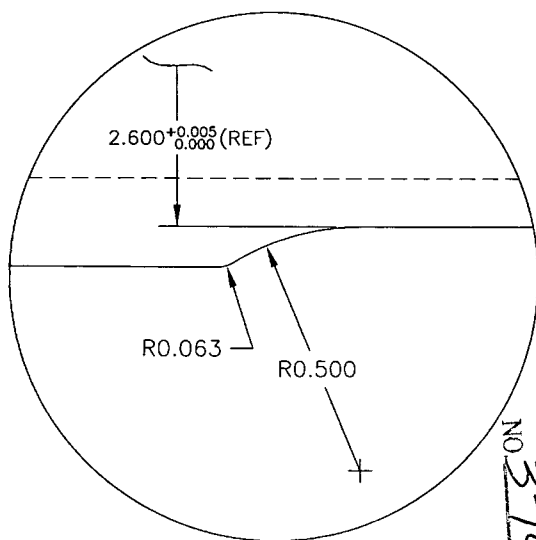


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674424 P  
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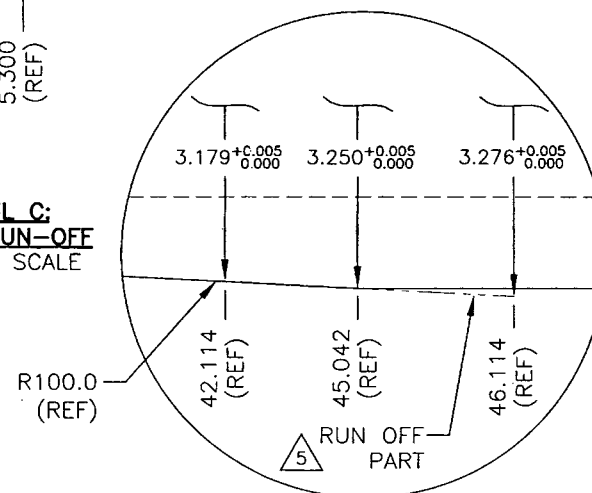
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
TRANSITION  
SCALE 4:1**



**DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE**



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D212-664-241	REV. C SHEET 3 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:1